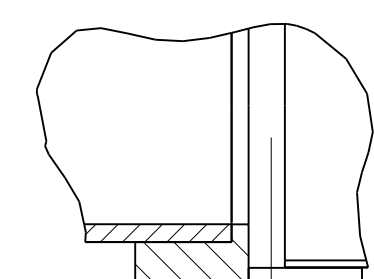
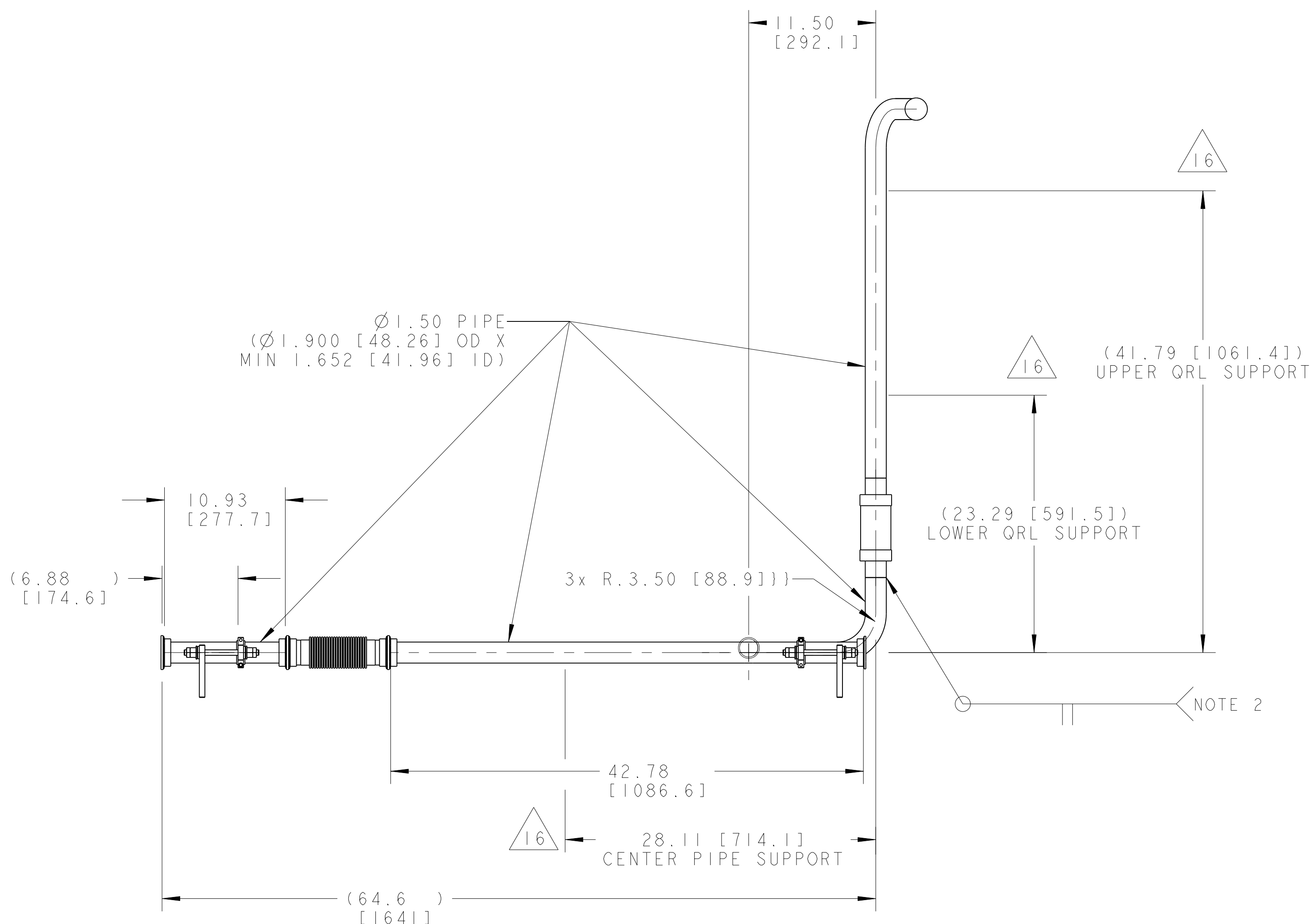
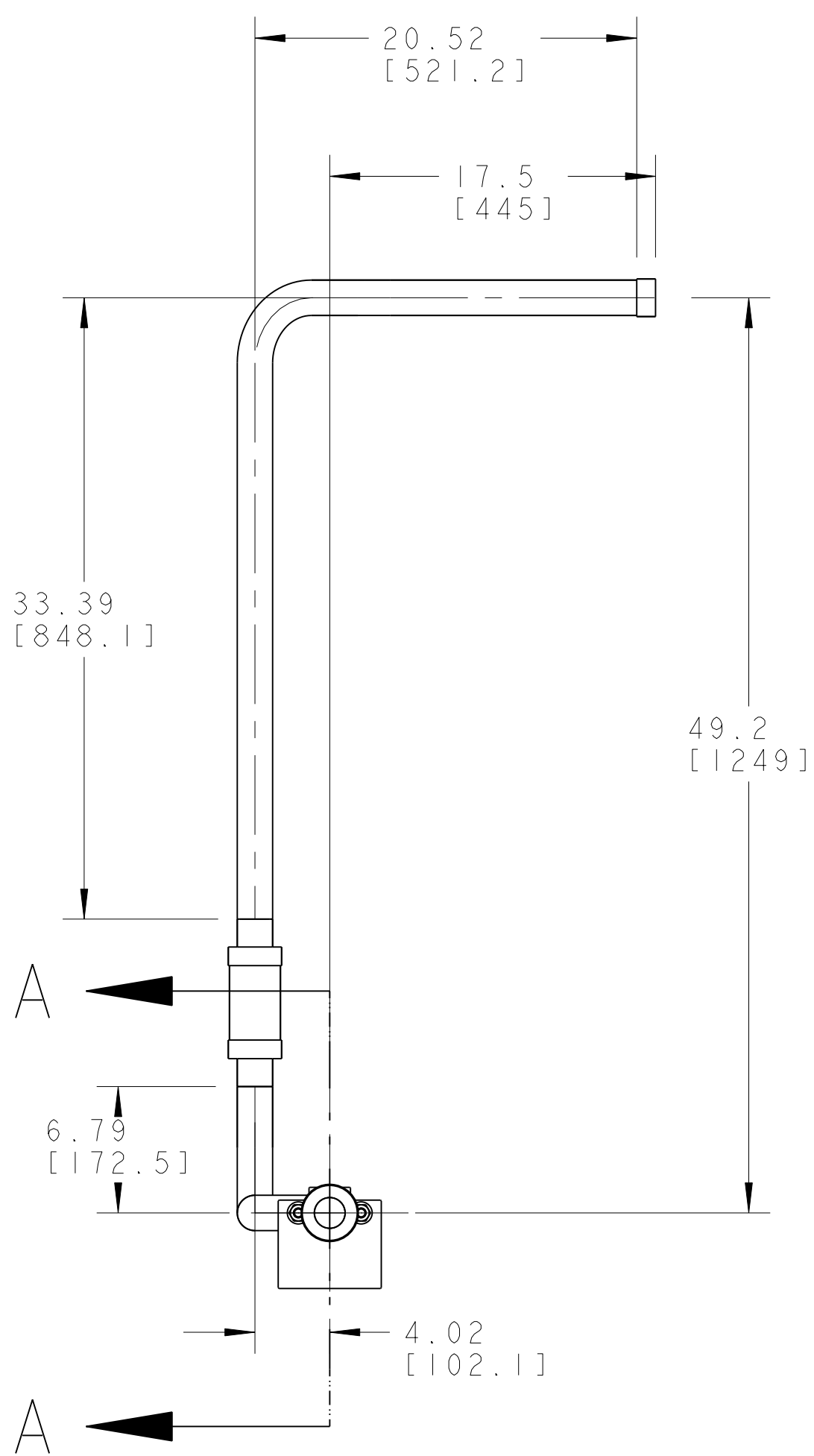


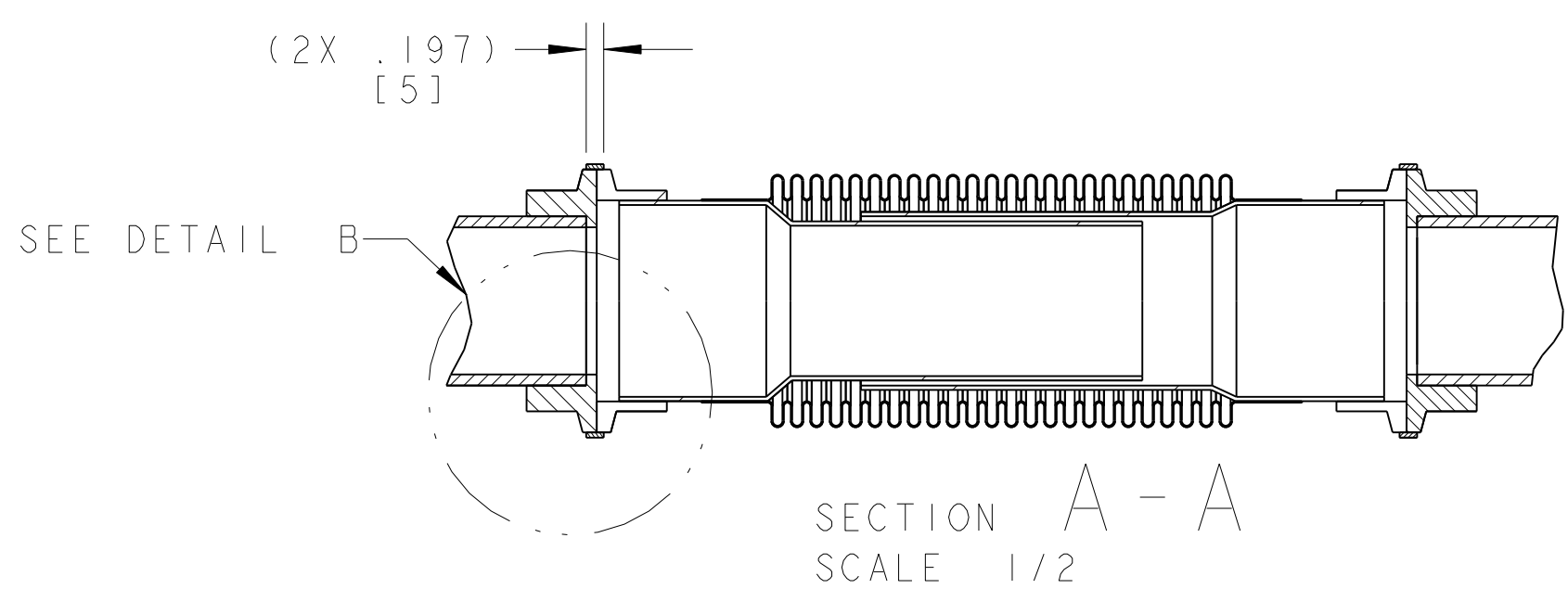
SCALE 3/16

NOTES: (UNLESS OTHERWISE SPECIFIED)

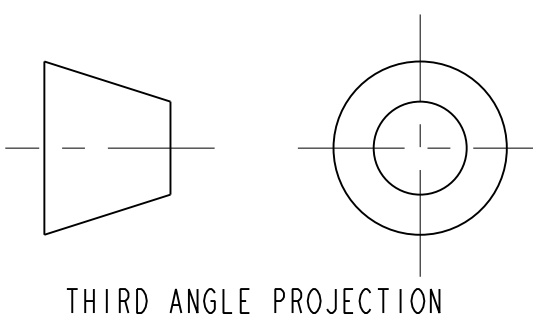
- THIS IS A CRYOGENIC VACUUM COMPONENT.
- WELDING PROCEDURE: PER VENDOR SPECIFICATION WITH LBNL APPROVAL.
- CLEANING PROCEDURE: PER VENDOR SPECIFICATION WITH LBNL APPROVAL.
- PACKAGING AND STORAGE PROCEDURE OF THE COMPONENTS: PER VENDOR SPECIFICATION WITH LBNL APPROVAL.
- DIMENSIONS AND TOLERANCING PER ANSI Y14.5M-1982. UNITS ARE IN INCHES [mm] UNLESS OTHERWISE SPECIFIED.
- USE OF SULFUR OR SILICONE BEARING OILS, LUBRICANTS, OR COOLANTS ARE STRICTLY PROHIBITED.
- USE OF RESIN OR RUBBER BONDED ABRASIVES UNDER POWER IS STRICTLY PROHIBITED. USE VITREOUS BONDED ABRASIVES ONLY.
- VENDOR SUGGESTED CHANGES TO WELD PREPS; SUBJECT TO LBNL APPROVAL.
- FITTINGS MAY BE USED IN PLACE OF BENDS; SUBJECT TO LBNL APPROVAL.
- VENDOR SUGGESTED CHANGES TO TOLERANCES TO FACILITATE FABRICATION OR ASSEMBLY; SUBJECT TO LBNL APPROVAL.
- REMOVE ALL THE BURRS AND REAM THE ENDS FOR CIRCULARITY AND CLEAN ENDS.
- TUBE END SURFACE MUST BE PERPENDICULAR TO THE TUBE AXIS WITHIN +/- .010.
- PERFORM ACCEPTANCE TESTS PER SECTION 3.2 OF LBNL SPECIFICATION M856.
- A MARK DESIGNATING THE INSTALLED LENGTH WILL BE UTILIZED DURING FINAL INSTALLATION OF THE FEEDBOX ASSEMBLY. MARK, SCRIBE OR ETCH THIS LOCATION IN A PERMANENT MANNER, SUBJECT TO LBNL APPROVAL, TO AN ACCURACY OF ± 0.063 ".
- PROVIDE A MINIMUM LENGTH OF 4.0" OF STRAIGHT, SMOOTH PIPE ON THE INDICATED SIDE OF THE INSTALLED LENGTH MARK FOR PIPE WELDING DURING FINAL INSTALLATION OF THE FEEDBOX ASSEMBLY.
- PIPE MUST BE STRAIGHT AND SMOOTH (NO BUMPS) FOR 0.5" ON EITHER SIDE OF THE CENTER-PLANE OF THE SUPPORT.
- CAP BOTH ENDS OF PIPE AFTER ACCEPTANCE TESTS PER SECTION 3.2 OF LBNL SPECIFICATION M856.



DETAIL B
SCALE 3/4



SECTION A-A
SCALE 1/2



THIRD ANGLE PROJECTION

REV	DWG	CHK	ZONE	DATE	INITIAL RELEASE	CHANGES
A	ARH	DPO		6/11/02		

ITEM	PART NO.	REQD	DESCRIPTION	MATERIAL
9	-	1	PIPE, THRUST SUPPORT	SS 304L
8	-	1	PIPE, LD3 OQL EXTENSION, UPPER	SS 304L
7	-	1	PIPE, LD3 EXTENSION	SS 304L
6	25H406	2	THRUST SUPPORT, BUS DUCT	SS 304L
5	-	1	PIPE, LD3 LOWER	SS 304L
4	-	3	WELD RING, ID 75mm, FNAL SUPPLIED	SS 304L
3	251307	4	FLANGE, FNAL # 5520-MB-390033	SS 300 SERIES
2	-	1	BRAIDED FLEX HOSE, 2" ID X 4' LL	SS 300 SERIES
1	251312	1	BELLOWS, FNAL # 5520-MC-390061	

ITEM	PART NO.	REQD	DESCRIPTION	MATERIAL
9	-	1	PIPE, THRUST SUPPORT	SS 304L
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7	-	1	PIPE, LD3 EXTENSION	SS 304L
6	25H406	2	THRUST SUPPORT, BUS DUCT	SS 304L
5	-	1	PIPE, LD3 LOWER	SS 304L
4	-	3	WELD RING, ID 75mm, FNAL SUPPLIED	SS 304L
3	251307	4	FLANGE, FNAL # 5520-MB-390033	SS 300 SERIES
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7	-	1	PIPE, LD3 EXTENSION	SS 304L
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4	-	3	WELD RING, ID 75mm, FNAL SUPPLIED	SS 304L
3	251307	4	FLANGE, FNAL # 5520-MB-390033	SS 300 SERIES
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